

# Work Order ID 77059

**\*77059\***

Page 1

November-25-11 8:33:51 AM

Item ID: D3278-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Support  
 Start Date: 25/11/2011 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 09/12/2011 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								

100 BAND SAW 0.00  
**\*100\***  
 Bandsaw Memo 0.00 OK 12/01/08 40 0  
 Jeaspa Bandsaw Cut blank: 2.00" x 1.00" x 2.550" long

110 HAAS CNC VERTICAL MACHINING #1 0.00  
**\*110\***  
 HAAS I Memo 0.00 OK 12/01/09 40 0  
 HAAS CNC vertical machine #1 1- Machine as per Folio FA405 and Dwg D32782- Deburr and Tumble/Identify as D3278-1

120 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*120\***  
 QC Memo 0.00 OK 12/01/09 40 0  
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 77059

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Page 2

November-25-11 8:33:51 AM

Item ID: D3278-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Support

Start Date: 25/11/2011 Start Qty: 40.00

\*40\*

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check 0.00

\*130\*

QC

Memo

0.00

Ba 12/01/10

40

φ

Quality Control

140 Chemical Conversion Coat per QSI005 4.1 0.00

\*140\*

HandFinish

Memo

0.00

Hand Finishing

m/ 12 01 11 40

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

\*150\*

Powdercoat

Memo

0.60

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

11-30

3250F

12-00

40xφ m/ 12/01/24

m119480

W/O:		WORK ORDER CHANGES					
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Work Order ID 77059

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Page 3

November 25-11 8:33:51 AM

Item ID: D3278-1

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Support

Start Date: 25/11/2011 Start Qty: 40.00

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Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish

0.00

\*160\*

QC Memo

0.00

Quality Control

40x 4 M 12/01/2011  
counter170 Identify as per dwg & Stock Location: ST GA 0.00

\*170\*

Packaging Memo

0.00

Packaging

(40x) SP 12-01-24

180 QC21- Final Inspection - Work Order Release 0.00

\*180\*

QC Memo

0.00

Quality Control

12/1/25

12-01-24

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November 25-11 8:33:55 AM

Page 1

WorkOrderID: 77059

\*77059\*

Parent Item: D3278-1

\*D3278-1\*

Parent Item Name: Support

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 40.00

Required Qty: 40.00

## Comments:

IPP: A04.04.19New issueKJ/JLM

IPP B 07.09.06 rev.c dwg EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	23.6460	0.2337	9.84			

\*M6061T6B1 000X02 000\*

\*\*

6061-T6 Bar 1.00 x 2.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT004	23.646	
112567	16.6	
118106	7.046	

1120044 X 9.84

12/10/08

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	77059
<b>Description:</b> Support		<b>Part Number:</b>	D3278-1
<b>Inspection Dwg:</b> D3278	<b>Rev:</b> C	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☐

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.099	—		Vern 7/106	
0.359	+/-0.005	.359	—			
0.609	+/-0.010	.613	—			
0.250	+/-0.010	.250	—			
1.480	+/-0.005	1.480	—			
R0.125	+/-0.010	R.125	—		R-L	
0.119	+0.005/-0.004	.121	—			
2.439	+/-0.010	2.440	—			
1.980	+/-0.010	1.980	—			
R0.13	+/-0.030	R.130	—		R-L	
Ø0.257	+0.005/-0.000	Ø.259	—			
R0.375	+/-0.010	R.375	—		R-L	
0.875	+/-0.010	.875	—			
0.500	+/-0.010	.500	—			
R0.400	+/-0.010	R.400	—		R-L	
R1.00	+/-0.030	R1.00	—		"	
1.720	+/-0.010	1.720	—			
R0.125	+/-0.010	R.125	—		R-L	
0.125	+/-0.010	.125	—			

<b>Measured by:</b>	anf
<b>Date:</b>	12/01/09

<b>Audited by:</b>	BA
<b>Date:</b>	12/01/10

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	EF

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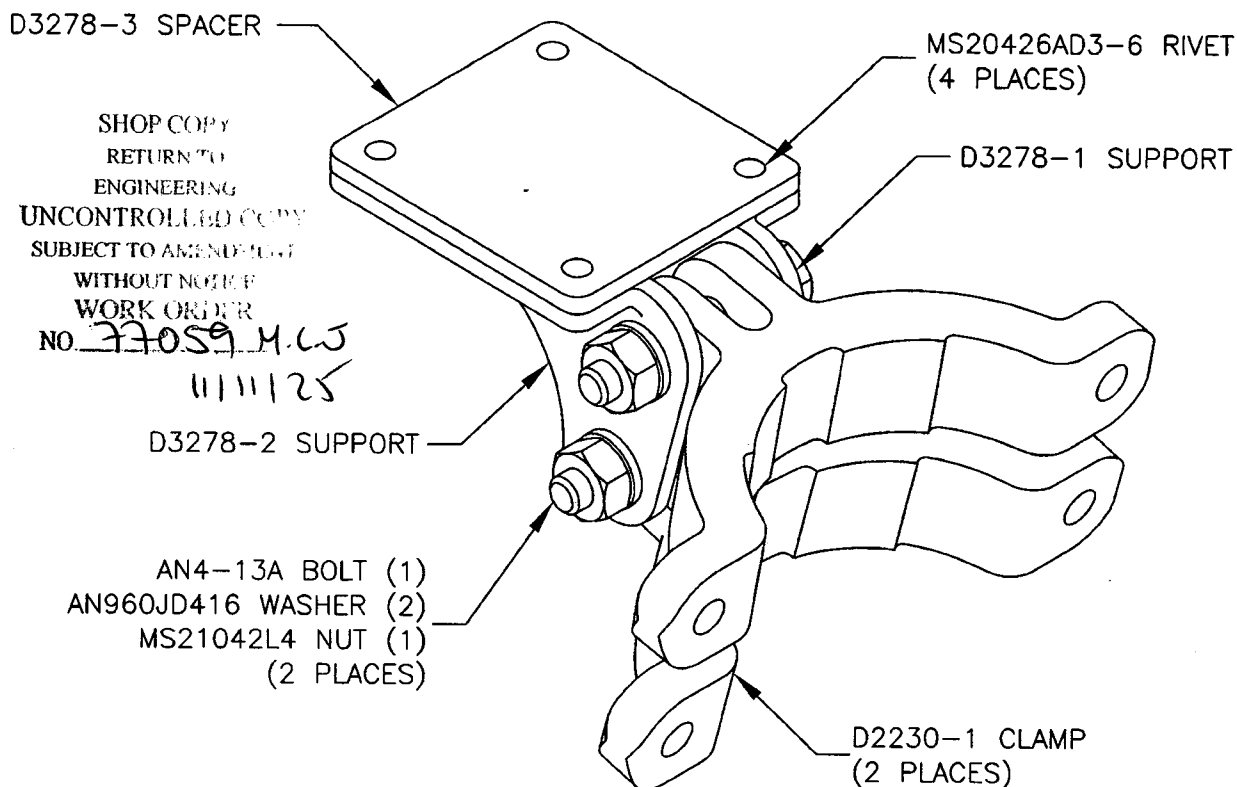
**NOTE:** Date & initial all entries

**DART**

DESIGN <i>97</i>	DRAWN BY <i>SC</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
*07-08-08*

## D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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# Dart Aerospace Ltd

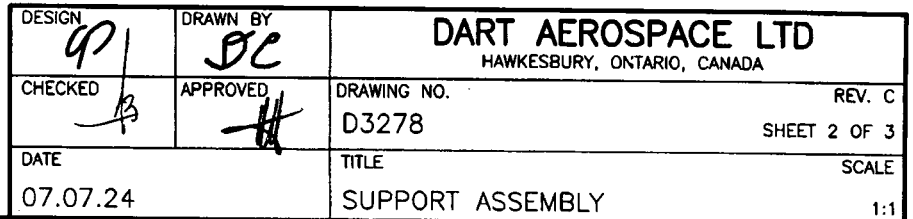
W/O:		WORK ORDER CHANGES					
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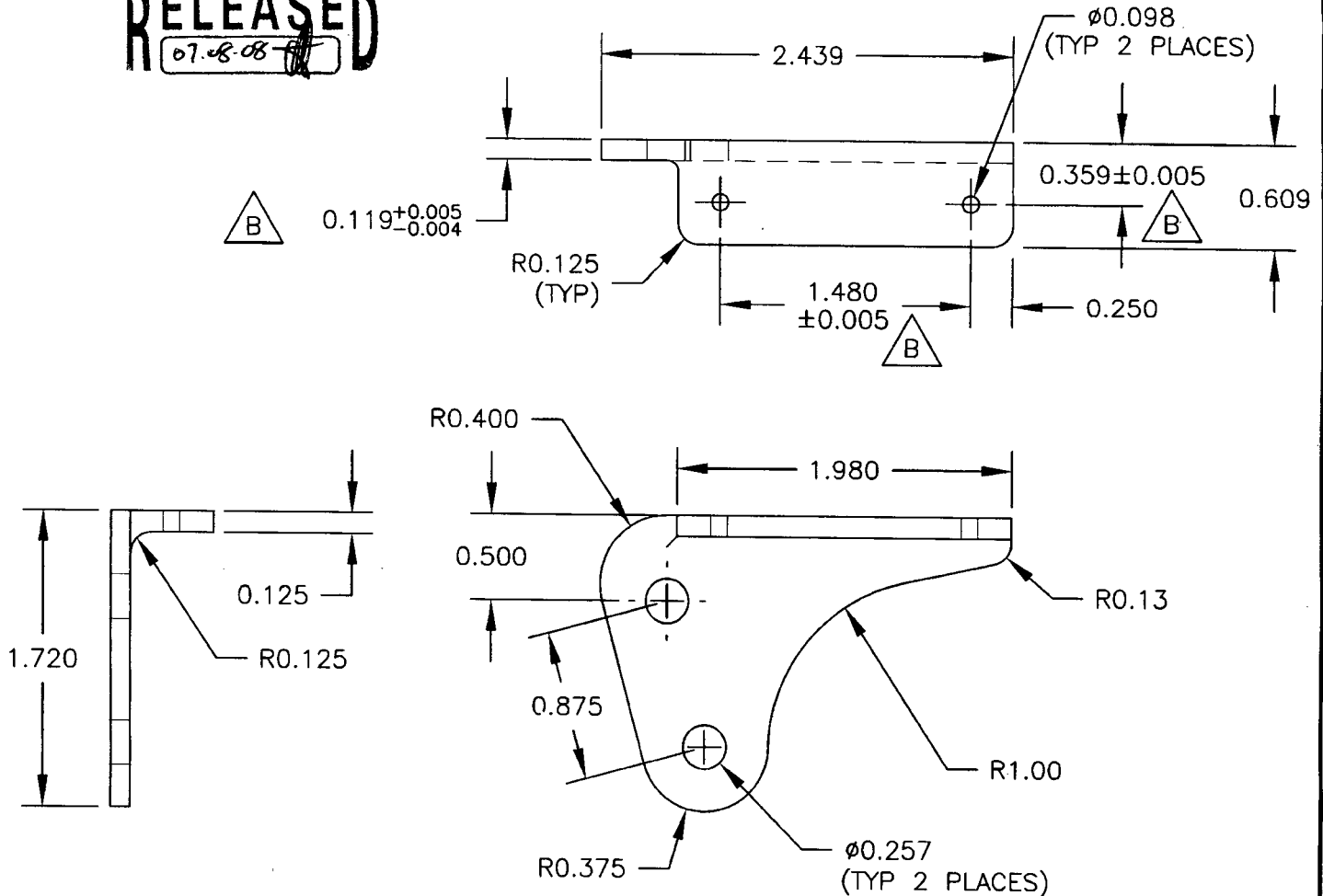
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RELEASED  
07-08-08



D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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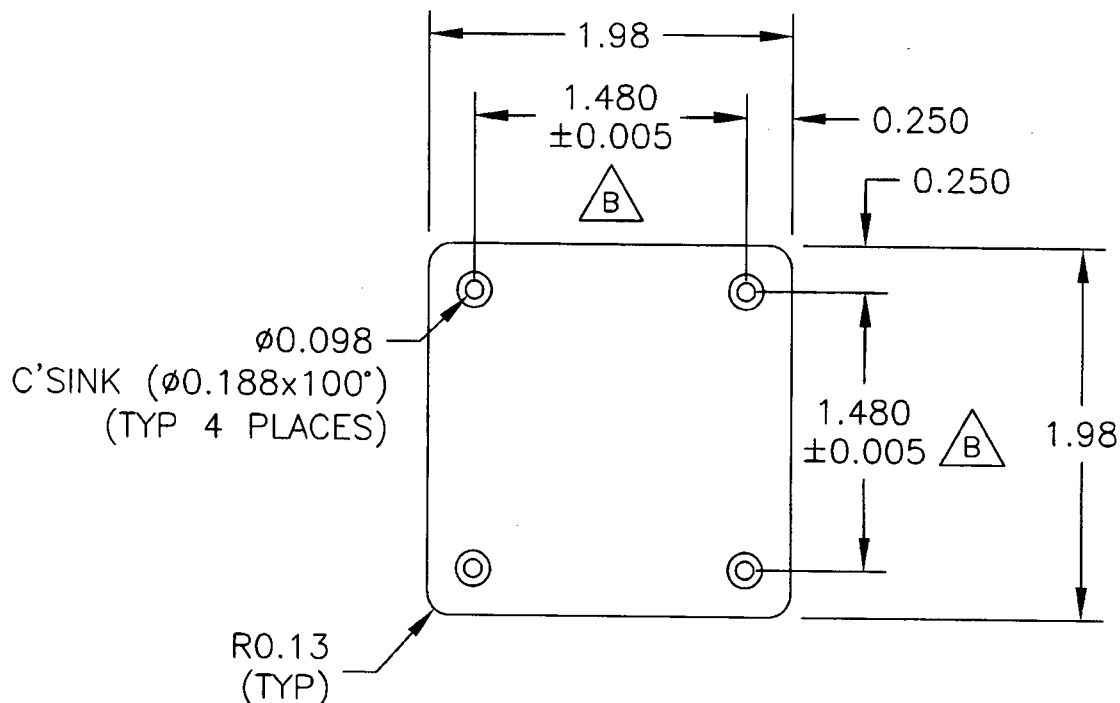
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>qp</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08

bsatt

**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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